

Work Order ID 84039

Tuesday, May 01, 2012 1:01:59 PM

84039

Eugle

Page 1

Item ID: D212-725-1-155F

Revision ID:

Item Name: Support Angle Oil Cooler

Start Date: 5/1/2012 Start Qty: 1.00

Required Date: 5/4/2012 Req'd Qty: 1.00

Reference:

Flat only

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

1

Cust Item ID:

1

Customer:

Approvals: Process Plan: mf

Date: 12-05-01 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D212-725-1 E

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

2074 .037

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

B2-5-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B2-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D212-725-1-155F

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Support Angle Oil Cooler

Stop *NS2*

Start Date: 5/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

Hand Finish

Memo

0.00

Hand Finishing

3 (20) 12/05/02

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

3 d 12/05/02

170

Identify as per dwg & Stock Location: 381

0.00

170

Packaging

Memo

0.00

Packaging

Eagle (30) 12/5/3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

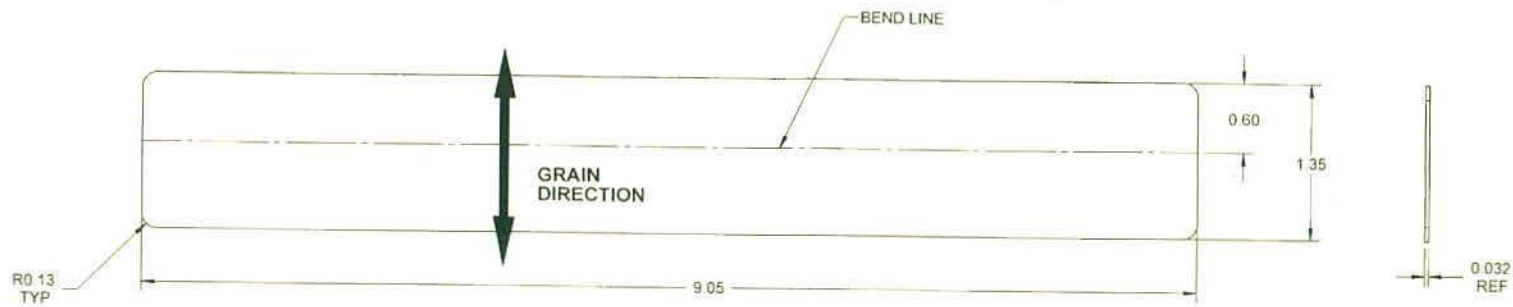
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D212-725-1-155F FLAT PATTERN

NOTES

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC. M2024T3S0.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

RELEASED
2011-08-25

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4242	REV. A
MFG. APPR	<i>[Signature]</i>	TITLE ANGLE	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR	<i>[Signature]</i>		
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED IN THE PUBLIC DOMAIN NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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